

Page 1

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83516

Thursday, April 19, 2012 10:27:22 AM

83516

Page 2

Item ID: D3371-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pedal Lock Cover
 Start Date: 4/19/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/27/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	2L	120629					
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							4 NG 12-7-3
145 *145* Powdercoat Powder Coating	Fire Red(Ref:4.3.5.10) per QSI005 4.3 Memo ***cover inside holes prior painting*** Start Time: 3:45 Oven Temperature: 320°F Finish Time: 4:15	0.00 0.00							4 X Ø MF 12/07/03

W 113645

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NOTE: Date & initial all entries

83516

Thursday, April 19, 2012 10:27:22 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 4/19/2012 **Start Qty:** 4.00

4

Customer:

Required Date: 4/27/2012 **Req'd Qty:** 4.00

4

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: GA

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

4x f H 12/07/08

4

SB
12/07/04

12/7/4

112-074

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, April 19, 2012 10:27:26 AM

Work Order ID: 83516

83516

Parent Item: D3371-3

D3371-3

Parent Item Name: Pedal Lock Cover

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A05.01.18New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.25 0		Purchased	No			100	f	14.8560	0.625	2.631579			

M6061T6B2 000X02 250

**

6061-T6 Bar 2.00 x 2.25

Location

Loc Qty

Loc Code

MAT009

14.856

118072

1.456

→ 119513

13.4

2.632 on 12/06/28

W/O:		WORK ORDER CHANGES					
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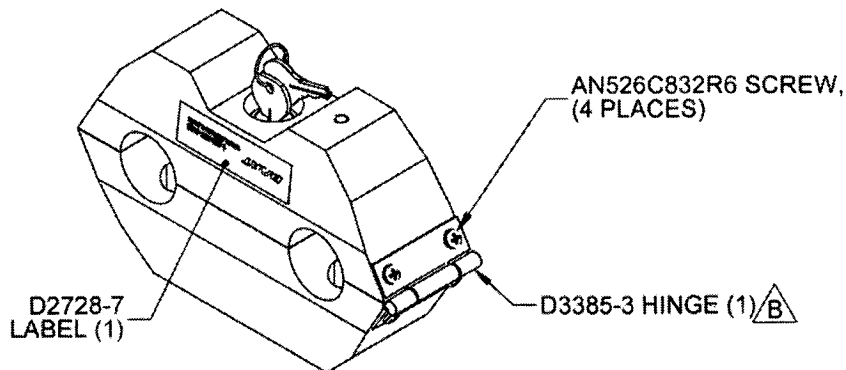
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

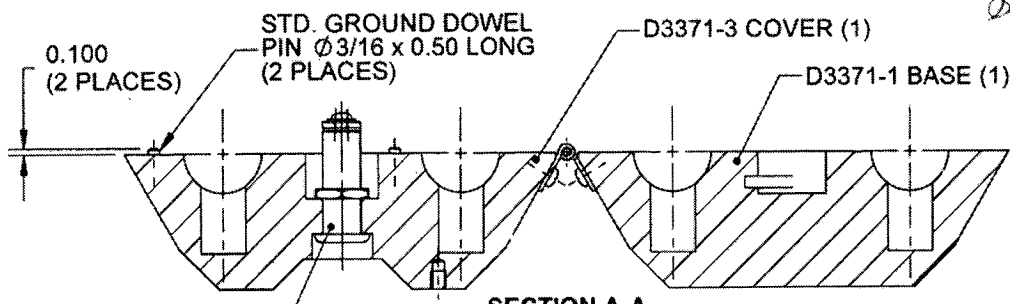
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83514

2/12-09-19

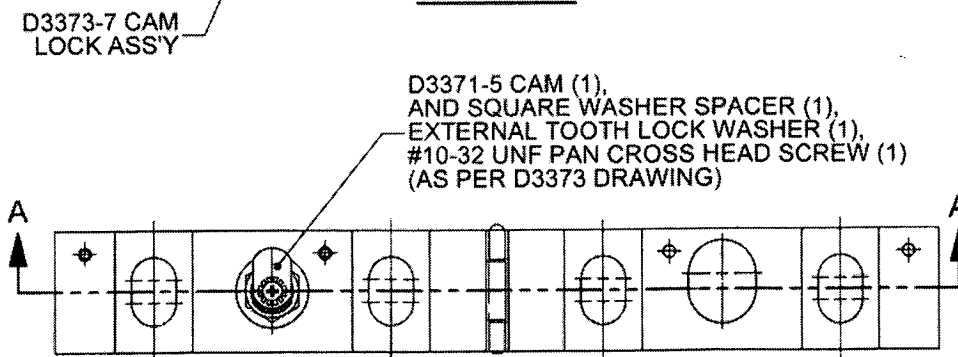


PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
[Signature]
05/04/28



SECTION A-A



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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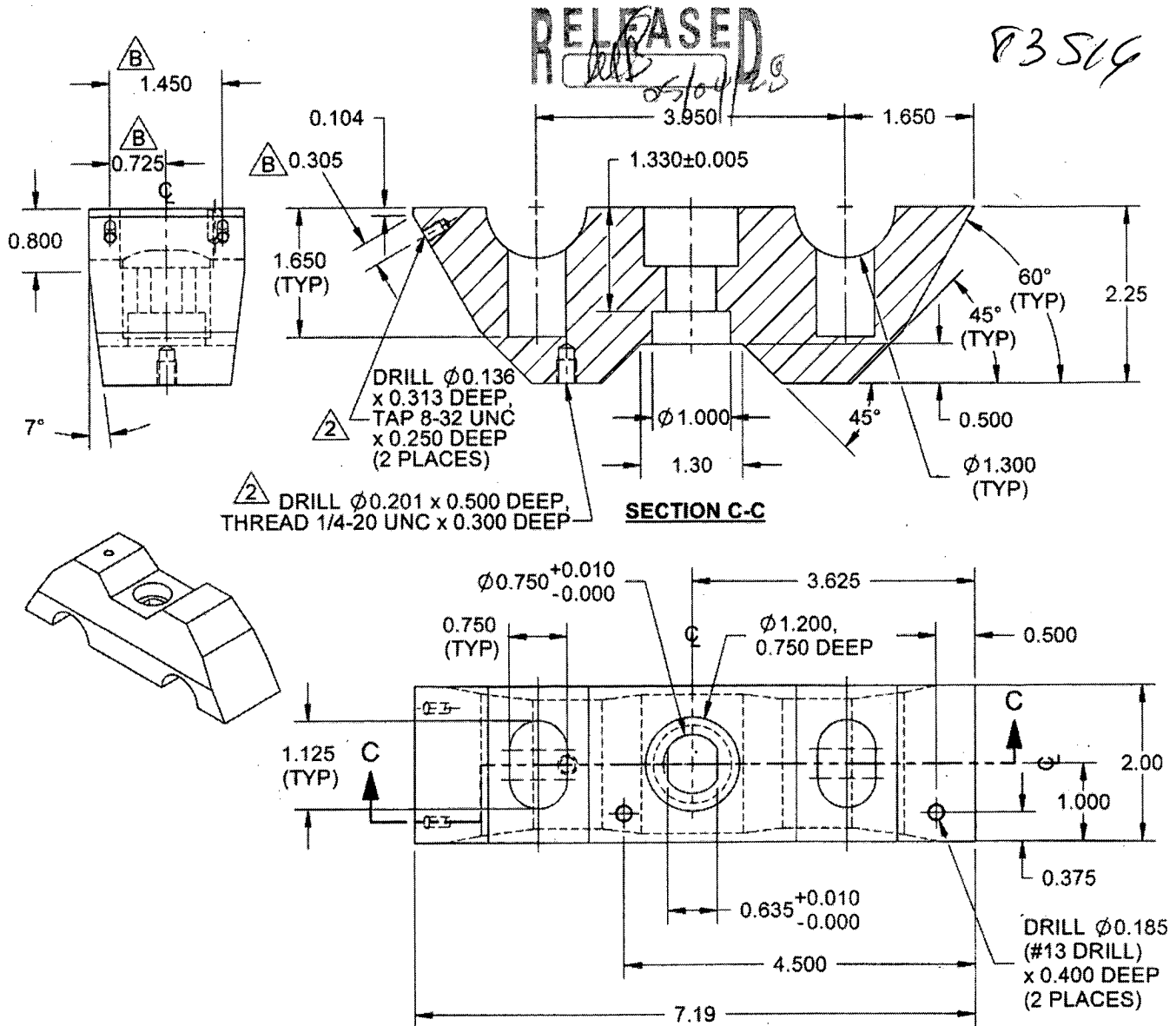
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22	TITLE PEDAL LOCK	SCALE 1:2	

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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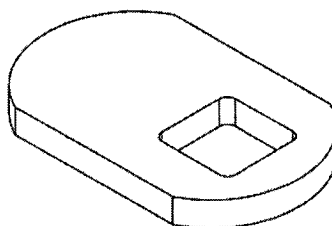
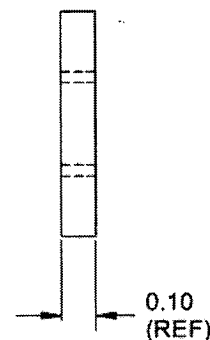
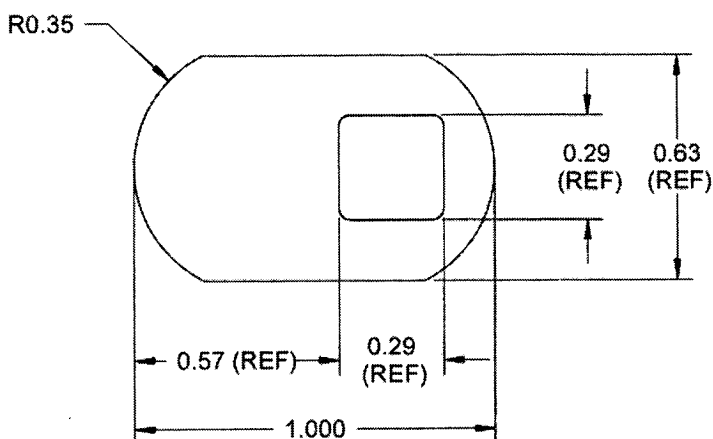


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

RELEASED
[Signature]
05/04/22

SPECIFICATION CONTROL DRAWING

83516



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 83516
Description: COVER		Part Number: D3371-3
Inspection Dwg: D3371 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
60°	± 1/2°	60°	—		HL-GBR	
2.25	± .030	2.250	—		Vern ML-06	
45°	± 1/2°	45°	—		HL-LBR	
.500	± .080	.503	—		Vern ML-06	
Ø1.300	± .010	Ø1.296	—		"	
Ø1.000	± .010	Ø1.000	—		"	
1.30	± .030	1.300	—		"	
1.650	± .010	1.650	—		"	
.305	± .010	.310	—			
.104	± .010	.101	—		"	
1.450	± .005	1.450	—		"	
7°	± 1/2°	7°	—		HL-LBR	
1.125	± .010	1.125	—		Vern ML-06	
.750	± .010	.750	—		"	
Ø.750	± .010	Ø.753	—		"	
3.625	± .010	3.620	—		"	
Ø1.200	± .010	Ø1.200	—		"	
.750 ±	± .010	.750	—		"	
.500	± .010	.494	—		"	
2.00	± .030	2.000	—		"	
1.00	± .030	1.000	—		"	
.375	± .010	.375	—		"	
Ø.185	± .005	Ø.187	—		"	

Measured by: <i>ML</i>	Audited by: <i>U</i>	Preliminary Approval:
Date: 12/06/29	Date: 12-06-29	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

